

Split

Work Order ID 147805-2

Wednesday, June 15, 2016 8:15:25 AM

147805

Item ID: D2855

Revision ID:

Item Name: Cap

Start Date: 6/20/2016

Start Qty: 25.00

Required Date: 6/30/2016

Req'd Qty: 25.00

Reference:

89

Accept

N900040100

Setup

Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D2855

Rev B

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 32724 Cast per Dwg D2855 Material Release Note
Required
Supplier: Metallurgie SYCA

100 JUN 16 2016

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.08

Packaging

Ensure Material Release Note is attached

104x 80/6-7-21

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

104

JUL 22 2016

Work Order ID 147805

Wednesday, June 15, 2016 8:15:25 AM

147805

Page 2

Item ID: D2855

Revision ID:

Item Name: Cap

Start Date: 6/20/2016 Start Qty: 25.00

Required Date: 6/30/2016 Req'd Qty: 25.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

0.00

130

Small Fab

Small Fab

Memo

0.21

Small Fab

1- Drill as per Dwg D2855 using DT82352- Open holes to 19/64"3- Deburr

DAS
30
9-89
(89)

SEP 29 2016

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.08

Quality Control

(89)

DAS
38
9-89

SEP 29 2016

150

White Gloss(Ref 4.3.5.1) per OSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.04

Powder Coating

START TIME: 3:05 FINISH TIME: 9:10 OVEN TEMPERATURE: 9.40.

89 6/16-09-30.

DAS
34
9-89

Work Order ID 147805

Wednesday, June 15, 2016 8:15:25 AM

147805

Page 3

Item ID: D2855

Revision ID:

Item Name: Cap

Start Date: 6/20/2016 Start Qty: 25.00

Required Date: 6/30/2016 Req'd Qty: 25.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.04

Quality Control

x89 d ll 16/10/05 **DAS 15 9-89**

170

Small Fab

0.00

170

Small Fab

Memo

0.13

Small Fab

Install Inserts as per Dwg D2855

(x89) ~~Ø~~ 2d6/10/05 **DAS 15 9-89**
BEB.

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.08

Quality Control

x89 d ll 16/10/05 **DAS 15 9-89**

Work Order ID 147805

Wednesday, June 15, 2016 8:15:25 AM

147805

Page 4

Item ID: D2855

Revision ID:

Item Name: Cap

Start Date: 6/20/2016 Start Qty: 25.00

Required Date: 6/30/2016 Req'd Qty: 25.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

190

Identify as per dwg & Stock Location: FP001

0.00

190

Packaging

Memo

0.04

Packaging

LOCATION: FP001

2016/10/05
BEB

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.42

Quality Control

DAS
21
9-89

OCT 06 2016

DAS
21
9-89

OCT 05 2016

Picklist Print

Wednesday, June 15, 2016 8:15:35 AM

Page 1

Work Order ID: 147805

147805

Parent Item: D2855

D2855

Parent Item Name: Cap

Start Date: 6/20/2016

Required Date: 6/30/2016

Start Qty: 25.00

Required Qty: 25.00

Comments: IPP: B00.06.22 Added receiving step & removed P/O for powder coat EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-225	AELS8-1032-225	Purchased	No			100	Each	451.0000	2	50			

AI S7-1032-225

Insert

***ALS4-1032-225**

Location

Loc Qty

Loc Code

EG

120

***M135603**

***178**

118520

120

FP001

331

m131657

16

m133799

315

D2855P

Purchased

No

170

Each

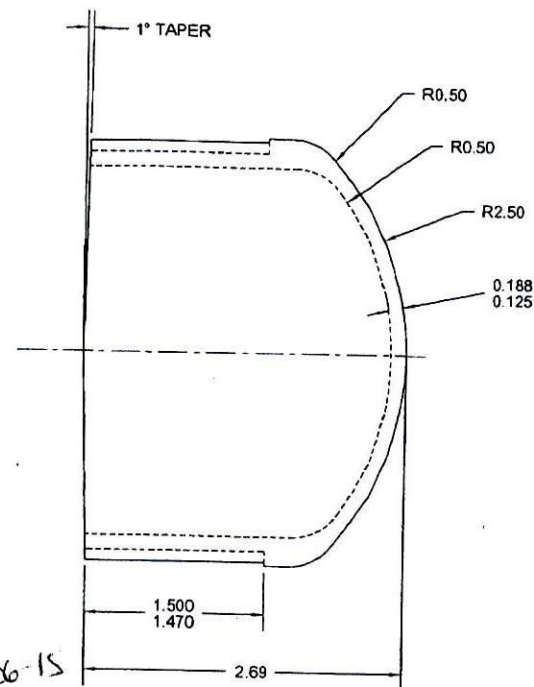
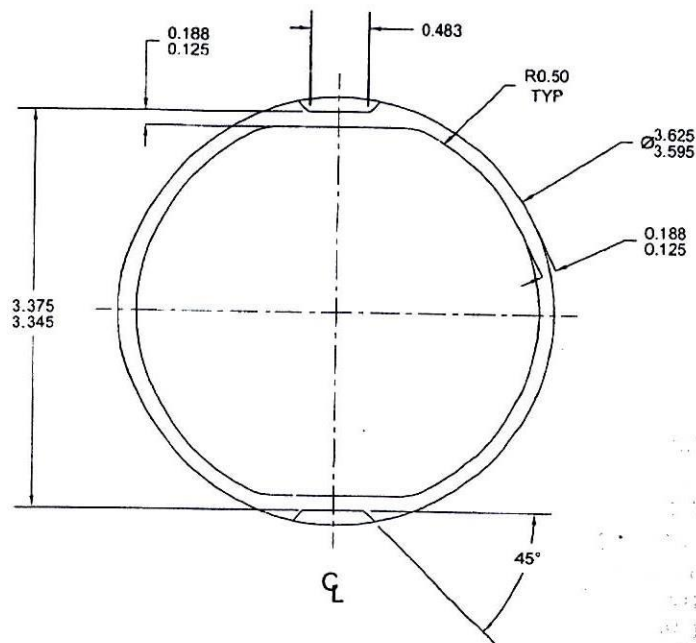
0.0000

1

D2855P

Cap

25/04/16
104x Sp/6-7-21



147805 16-06-15
MLJ

D2855C CASTING DETAIL

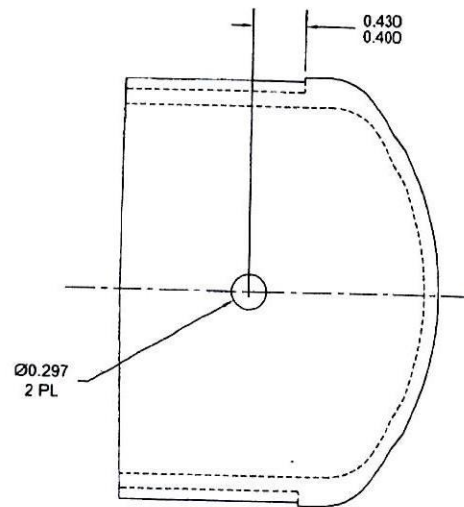
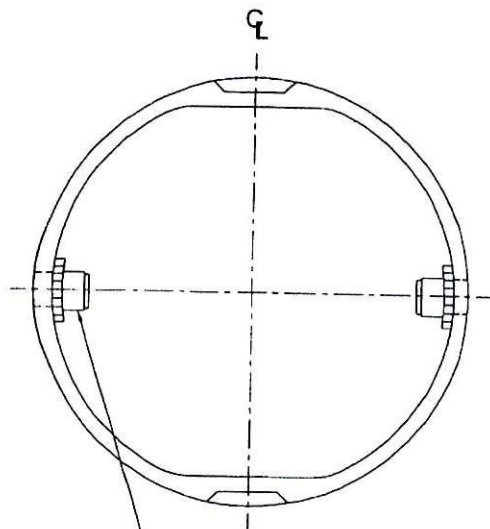


NOTES:

- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

RELEASED
09/07/15 MLJ

B	DRAWING UPDATED TO CURRENT STANDARDS. ADD D2855-3 & D2855C (ZN A4-1, A4-3)	RF	09.06.30
A	NEW ISSUE (WAS D2575 REV. E)	DS	96.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D2855	SHEET 1 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. NO PART OF THIS DOCUMENT IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

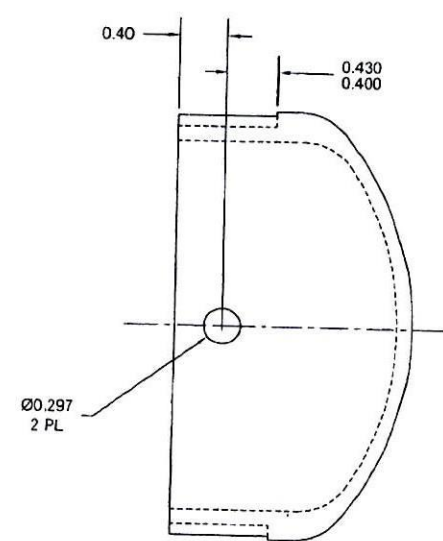
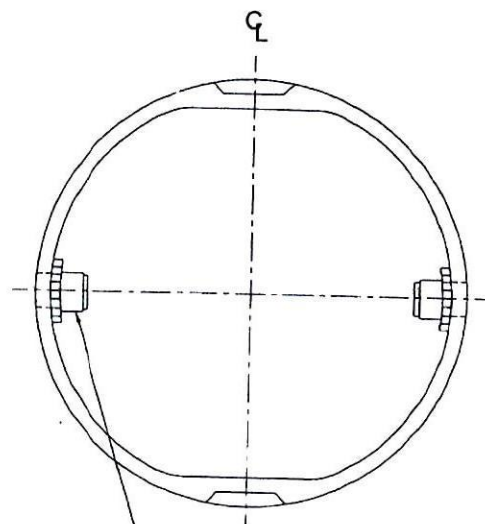
D2855 CAP
(MAKE FROM D2855C CASTING)

NOTES:

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

RELEASED
21/07/19

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	EP	D2855	SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	CAP	NTS
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INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855-3 CAP 
(MAKE FROM D2855C CASTING)

NOTES:

- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

RELEASED
09/17/15

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D2855	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CAP	NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO32724

Purchase Order Date 6/16/2016 10:32:03 AM
PO Print Date 6/16/2016

Page Number 1 of 2

Order From :
METALLURGIE SYCA
500 PRINCIPALE
ST.DOMINIQUE, QUEBEC JOH 1LO

VC-MSY01

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

JUN 16 2016

E-MAILED

Contact Name
Vendor Phone 450-261-0853
Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

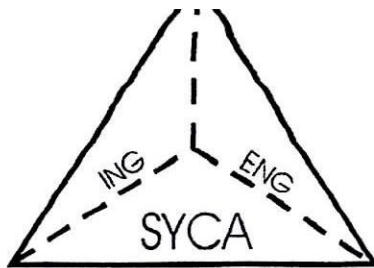
Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2855P AS PER DWG D2855 REV. B B147805	Cap	7/12/2016 Yes 7/12/2016		100.00 Each	\$13.50	\$1,350.00
Line Total:							\$1,350.00
4	71401-45	ADMIN FEES CERTIFICATE OF COMPLIANCE	7/12/2016 Yes 7/12/2016		1.00	\$75.00	\$75.00
Line Total:							\$75.00

PO Instructions: Fedex Acc#151793240

Note:

6/16/2016



W W W . S Y C A - I N C . C O M

500, Principale
St-Dominique, Québec

J0H 1L0

Tél: (450) 261-0853

Fax: (450) 261-0894

E-mail: syca@qc.aira.com

CERTIFICATE OF COMPLIANCE

COMPANY: DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKSBURY, ONTARIO
K6A 1K7

DATE: 2016-JULY-19TH

SHIPPING MEMO: 787951

TRANSPORT: VIA FEDEX COLLECT

NUMBER OF PAGES: 2

DESCRIPTION	QUANTITY	PART CODE	P.O NUMBER
CAP D-2855	104	D-2855	32724

All items specified in this compliance certificate are manufactured in Canada.

-PRODUCTION LOT: KJJ01072016

-ALLOY: A-356

-NORME: ASTM B-85

-CHEMICAL ANALYSIS: SUPPLY

-VISUAL INSPECTION: DONE

-DIMENSIONAL INSPECTION: NON-APPLICABLE

-SURFACE SMOOTHNESS : ALUMINIUM ASSOCIATION DATA

SA-101

RESPONSIBLE: CARL JOBIN ING.

ROUVILLE STATION INC.
1032, BOUL. RICHELIEU
RICHELIEU (QUÉBEC)
J3L-0L7

TEL : (450) 658-2183

TEL : (450) 658-2808

FAX : (450) 658-1461

Coulée # 118 SR

<u>ELEMENT:</u>	SI	FE	CU	MG	MI	NI	TI	ZN	CR	SR
ALLIAGE	6.5 - 7.5	.50	.10	.30 - .45	.0	*	.20	.05	*	*
(356.1)										.007
<u>A356.0</u>		.20	.20	.25 - .45	.1		.20	.10		
<u>ANALYSE MOYENNE:</u>	7.2	.21	.03	.38	.1	.09	.107	.002	.003	.002

CHEF DE LABORATOIRE:



Dte : 25-08-2015